

SG Corten

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated welding wire developed for MAG welding of weather resistant steels.

APPLICATIONS Weather resistant steels, art constructions, bridges, ovens, deco parts etc.

PROPERTIES Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas. Due to the addition of 0,5% copper this alloy offers excelent weather resistant properties.

CLASSIFICATION
 AWS A.5.28: ER 80 S-G
 EN ISO 14341-A: G 42 2 M/C GO
 DIN 8575: SG NiCu

SUITABLE FOR S235J2G3 Cu, S355J2G3 Cu, S235JRW, S355JRW, S235J2W, S355J2W, CORTEN, PATINAX 37, ALCODUR 50, KORALPIN 52, 1.8962, 1.8963

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cu	Ni	Mo
0.09	1.40	0.85	0.45	0.85	

MECHANICAL PROPERTIES

Shield gas	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				+20°C	-40°C
C1	> 450	> 570	> 26	> 90	
M21	> 480	> 590	> 24	> 100	> 50

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8		60-200	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600
1.0		80-300	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600
1.2		120-380	KD-300 / Drum / B3	15 / 250 / 300	1080 / 1000 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21, C1